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IN THE UNITED STATES PATENT AND TRADEMARK OFFICE

NEW UNITED STATES PATENT APPLICATION

Assistant Commissioner of Patents
Washington, D.C. 20231

Attorney Docket No. 01309.08932

Sir:

Enclosed herewith for filing is a patent application entitled METHOD OF MANUFACTURING LIGHTING UNIT
by the following named inventor(s).

Full Name of Inventor	Family Name	First Given Name	Second Given Name
	YONEDA	Kenji	
Residence & Citizenship	City	State or Foreign Country	Country of Citizenship
	Kyoto	Japan	Japan
Post Office Address	Post Office Address	City	State & Zip Code/Country
	Saganohaitu 518, 26 Sagano Shibano-cho, Ukyo-ku, Kyoto-shi	Kyoto	616 Japan

1. Specification 10 pages / 2 claims (1 independent) / Abstract
2. Declaration/Power of Attorney is:
 - attached in the regular manner.
 - NOT included, but deferred under P.L. 97-247.
3. 4 Sheets of Formal Informal Drawings
4. Preliminary Amendment which is to be considered a part of the disclosure as to any change in the executed specification and thus outside any proscription under 37 C.F.R. 1.118.
5. Preliminary submission of an Information Disclosure Statement which is to be considered a part of the disclosure as to any change in the executed specification and thus outside any proscription under 37 C.F.R. 1.118.
6. An Assignment of the invention in favor of the following organization is enclosed for recordation:
7. Priority is hereby claimed under 35 U.S.C. § 119 based upon the following application(s):

Country	Application Number	Date of Filing (day, month, year)
Japan	8/178034	8 July 1996

8. Priority document(s) is attached hereto.
9. A Verified Statement Claiming Small Entity Status is attached hereto.

10. Calculation of Fees:

FEES FOR	NUMBER EXTRA	RATE	CALCULATIONS
Basic Filing Fee			\$770.00
Total Claims in Excess of 20	0	22.00	0.00
Independent Claims in Excess of 3	0	80.00	0.00
Multiple Dependent Claims (if applicable)	0	260.00	0.00
Subtotal - Filing Fee Due			770.00
Reduction by 50%, if Small Entity (Note 37 C.F.R. § 1.9, 1.27, 1.28)	770.00	0	0.00
Total Filing Fee Due			770.00
Assignment Recordation Fee (if applicable)	0	40.00	0.00
GRAND TOTAL DUE			770.00

11. PAYMENT is:

- included in the amount of the GRAND TOTAL by our enclosed check. A general authorization under 37 C.F.R. § 1.25(b), second sentence, is hereby given to credit or debit our Deposit Account No. 19-0733 for the instant filing and for any other fees during the pendency of this application under 37 C.F.R. § 1.16 (filing) and 37 C.F.R. § 1.17 (processing) under P.L. 97-247.
- not included, but deferred.

12. All correspondence for the attached application should be directed to:

Franklin D. Wolffe, Esq.
 Banner & Witcoff, Ltd.
 1001 G Street, N.W.
 Washington, D.C. 20001-4597
 Telephone: (202) 508-9100

Date: June 18, 1997

By:

Franklin D. Wolffe
 Reg. No. 19,724



FDW:lab

UNITED STATES PATENT SPECIFICATION

TO ALL WHOM IT MAY CONCERN:

BE IT KNOWN THAT, I, Kenji YONEDA, of Japanese Nationality, residing at Saganohaitsu 518, 26 Sagano Shibano-cho, Ukyo-ku, Kyoto-shi, Kyoto 616 JAPAN, has invented certain new and useful improvements in

METHOD OF MANUFACTURING LIGHTING UNIT
of which the following is a specification.

BACKGROUND OF THE INVENTION

This invention relates to a method of manufacturing a lighting unit which is preferably used when a product inspection is conducted by means of reflected light
5 emitted by the lighting unit.

As a method for examining a surface of a product it has generally been known that a product to be examined is irradiated by a lighting unit through its underside and then the reflected light is visually inspected or taken a
10 photo in close proximate to the lighting unit. If there exists some unevenness in light intensity on the surface to be examined, it may happen that a micro flaw or a finishing defect on the surface of the product to be examined is failed to be detected. Therefore, in order to
15 examine a surface of a product it is very popular to use a lighting unit having such an arrangement that a plurality of illuminants such as light-emitting diodes are placed all over the underside of the lighting unit and the whole underside thereof emits light areally so as to keep the
20 light intensity on the surface to be examined even.

Especially in case that a product to be examined is three-dimensional, it is necessary to light up the product to be examined from not only one direction but also several directions as if to cover the product. In such a case it
25 is usual to use a lighting unit having such an arrangement that the underside of the lighting unit, namely the surface which emits light is a concave face of a hollow truncated cone shape and that a plurality of illuminant

are arranged on the concave face.

However, if a lighting unit has the above-mentioned arrangement, in order to place a plurality of illuminants all over the underside of the lighting unit, complicated steps have to be taken, such as to process the underside of the lighting unit to form a concave face of a hollow truncated cone or a hollow conic, to perforate a plurality of holes on the concave face, to embed illuminants in each of the holes respectively, and then to wire each of the illuminants by hand. This makes it difficult to assemble the lighting unit having the above-mentioned arrangement, thereby taking longer time to assemble the lighting unit. This also makes it difficult to standardize a process of manufacturing a variety of lighting units having different angle of emitting light because every step such as processing the underside of the lighting unit or the angle of a hole perforated varies.

It is an object of the present invention to provide a method of manufacturing a lighting unit characterized by that the lighting unit having such an arrangement that a plurality of illuminants are set up on a concave face of a hollow truncated cone shape can easily be manufactured.

SUMMARY OF THE INVENTION

In order to accomplish the above-mentioned object the invention has adopted the following method. The method of manufacturing a lighting unit in accordance with the invention comprises the following steps of holding a flexible circular board having a concentric circular hole

and a cutout which has at least two sides in a planar state, embedding a plurality of illuminants in the board, and jointing one side of the cutout and the other side of the cutout or holding both sides in close contact so as to
5 place the illuminants in the side of the concave face.
With the above-mentioned method, a plurality of illuminants can easily be set up on a concave face of the hollow truncated cone-shaped board.

More specifically, the invention is a method of
10 manufacturing a lighting unit characterized by obtaining the lighting unit in which a plurality of illuminants are arranged on a concave face of a board formed into a shape of a hollow truncated cone and the illuminants are mounted on the underside of the lighting unit through the board by
15 the steps of holding the flexible circular board having a concentric circular hole and a cutout which has at least two sides in a planar state, embedding a plurality of illuminants such as light-emitting diodes or the like in the board, and then jointing one side of the cutout and
20 the other side of the cutout of the board or holding both sides in close contact.

In particular, in order to further simplify assembling operations, it is preferable to use a printed circuit board as the above-mentioned board so that the
25 operations of wiring each illuminants and embedding each illuminants in a board can be done at once.

In accordance with the invention, the following effects are achieved.

It becomes possible to easily set up a plurality of illuminants on a concave face of a hollow truncated cone-shaped board by the following steps. First, hold the flexible circular printed circuit board having a

5 concentric circular hole and a cutout which has at least two sides in a planar state. Next, embed a plurality of illuminants in the board. Finally, joint one side of the cutout and the other side of the cutout or hold both sides in close contact so as to place the illuminants in the

10 side of the concave face. As a result of this, it is not necessary to provide a complicated process to the underside of the lighting unit, which makes it easy to assemble the lighting unit, thereby to shorten the time required to assemble. In addition, since emitting angle

15 can easily be changed just by changing a diameter of a board or a size of a cutout, it is easy to manufacture a variety of lighting units with various angle of emitting light up so as to fit to light a product to be examined.

If a printed circuit board is used as a board, wiring

20 operation is completed just by embedding the illuminants in the board. Then a process of assembling the lighting unit is simplified because a complicated process such as wiring each of the illuminants can be omitted.

BRIEF DESCRIPTION OF THE DRAWINGS

25 The objects and features of the invention may be understood with reference to the following detailed description of illustrative embodiments of the invention, taken together with the accompanying drawings in which;

Fig. 1 is a cross sectional end view of a lighting unit showing a preferred embodiment of this invention,

Fig. 2 is a front view showing the board on which illuminants are mounted prior to assembling of the
5 lighting unit shown in Fig. 1,

Fig. 3 is a cross sectional end view of a lighting unit showing a modification of the preferred embodiment, and

Fig. 4 is a front view showing the board on which
10 illuminants are mounted prior to assembling of the lighting unit shown in Fig. 3.

DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENTS

An embodiment of the invention will now be described below with reference to Fig. 1 and Fig. 2.

15 As shown in Fig. 1, a plurality of illuminants 1 such as light-emitting diodes are arranged on a underside of a lighting unit 4, namely on a concave face 2c of a hollow truncated cone-shaped flexible printed circuit board 2 and a lighting case 3 holds the illuminants 1 together with
20 the board 2. Power is supplied to each of the illuminants 1 from a power cable 5 through the board 2. The lighting case 3 is provided with a center hole 32 for visual inspection or taking photos and a frame 33 for retaining the illuminants 1 and the board 2. An internal thread 31
25 formed in the lighting case 3 is for mounting the lighting unit 4.

With the above-mentioned arrangement, a method of manufacturing a lighting unit in accordance with the

invention will now be explained. First, hold a flexible printed circuit board 2 in a planar state. The shape of the board 2 is a circle with a concentric circle hole and a cutout having two sides 2a, 2b. Next, embed the

5 illuminants 1 in the board 2 by means of soldering or the like. Then joint one side 2a of the cutout and the other side 2b of the cutout or keep both sides 2a, 2b in close contact so as to place the illuminants 1 in the side of a concave face 2c. Then the board 2 is inevitably

10 transformed into a shape of a hollow truncated cone and the illuminants 1 are set up on the concave face 2c of the hollow truncated cone-shaped board 2. At the same time wire a power cable 5 in the board 2 by means of soldering or the like. Finally, mount thus formed board 2 and

15 illuminants 1 to the lighting case 3 through the frame 33, thereby to manufacture the lighting unit 4.

In accordance with the above-mentioned method of manufacturing the lighting unit 4, it is possible to embed the illuminants 1 in the board 2 when the board 2 is in a planar state. Therefore, in this case the same method can be applied as the method by which electrical parts are mounted on an ordinal printed circuit board. In addition to that, since the printed circuit board 2 is used as a board, wiring operation can be omitted just by embedding the illuminants 1 in the board 2 by means of soldering or the like, thereby to simplify a process of assembling the lighting unit 4. When one side 2a of the cutout and the other side 2b of the cutout are jointed or both sides 2a,

2b are kept in close contact so as to place the illuminants 1 in the side of a concave face, the board 2 is bent and inevitably transformed into a shape of a hollow truncated cone, which makes it easy to arrange the

5 illuminants 1 on the concave face 2c of the hollow truncated cone-shaped board 2. Thus formed board 2 and illuminants 1 are easily mounted to the underside of the lighting case 3 through the frame 33. Also there is no need of processing the lighting case 3 into a shape of

10 concave of a conic or a truncated cone nor need of perforating holes to embed illuminants. As shown in Figs. 3 and 4, a hollow truncated cone shape having an arbitrary size and angle can easily be formed just by changing a diameter of the board 2 or a size of a cutout. In

15 addition, emitting angle can easily be changed just by changing the frame 33 tailored to fit the truncated cone shape, namely by changing only a part of the lighting unit.

This invention is not limited to the embodiments

20 described in detail hereinabove. For example, the board 2 may be a shape of ellipsoid having a cutout to vary a shape of a surface emitting light.

Moreover, each of the arrangements is not limited to that illustrated in the figures and there may be various

25 modifications without departing from the spirit and essential characteristics thereof.

What is claimed is:

1. A method of manufacturing a lighting unit comprising steps of;

holding a flexible circular board having a concentric
5 circular hole and a cutout which has at least two sides in
a planar state,

embedding a plurality of illuminants in said board,
and

jointing one side of the cutout and the other side of
10 the cutout of said board or holding both sides in close
contact so as to form the board into a shape of a hollow
truncated cone with the illuminants placed in the side of
the concave face of said board,

so as to obtain the lighting unit in which a
15 plurality of illuminants are arranged on the concave face
of the board formed into a shape of a hollow truncated
cone.

2. The method of manufacturing a lighting unit as defined
in claim 1, wherein said board is a printed circuit board.

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ABSTRACT OF THE DISCLOSURE

An object of the invention is to make it easy to manufacture the lighting unit 4 in which a plurality of illuminants 1 are arranged on the concave face of a board 2 formed into a shape of a hollow truncated cone.

A method of manufacturing a lighting unit comprises the steps of holding a flexible circular printed circuit board 2 having a concentric circular hole and a cutout which has at least two sides 2a, 2b in a planar state, embedding a plurality of illuminants 1 in the board, and jointing one side 2a of the cutout and the other side 2b of the cutout or holding both sides 2a, 2b in close contact so as to place the illuminants 1 in the side of the concave face of the board 2.

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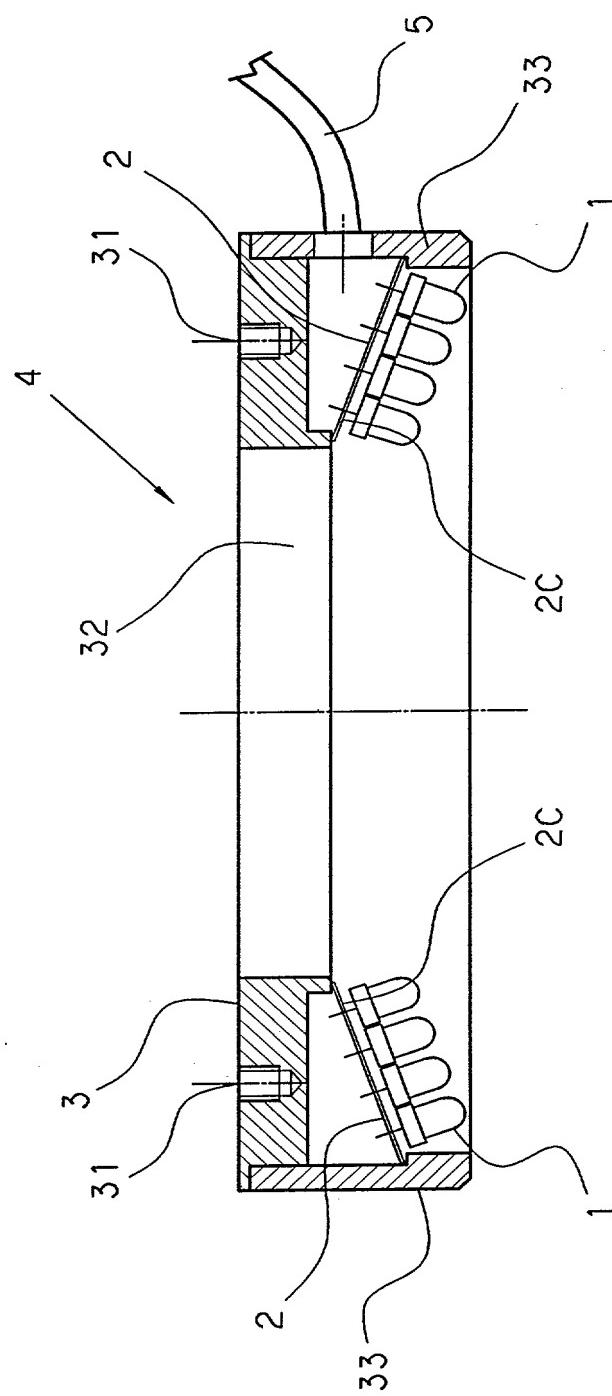


Fig. 1

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Fig. 2

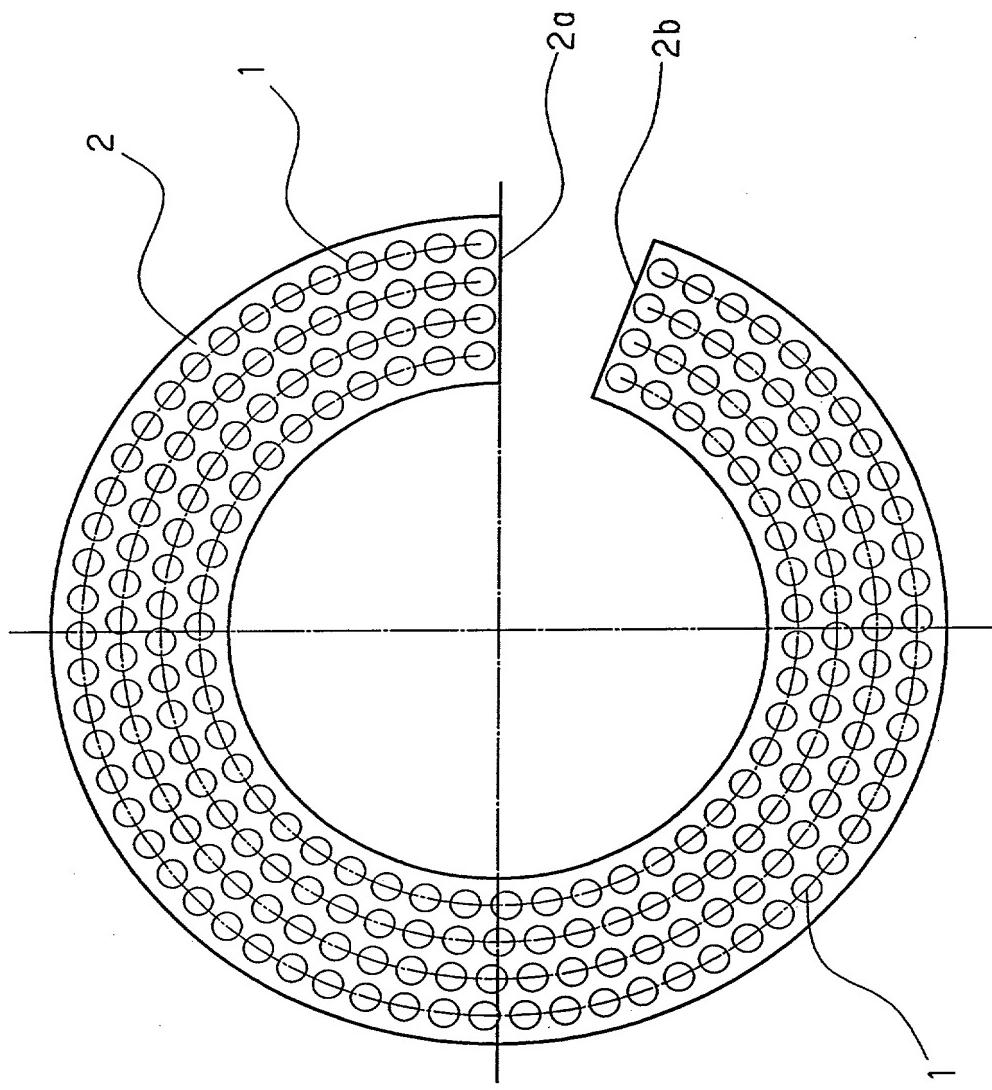
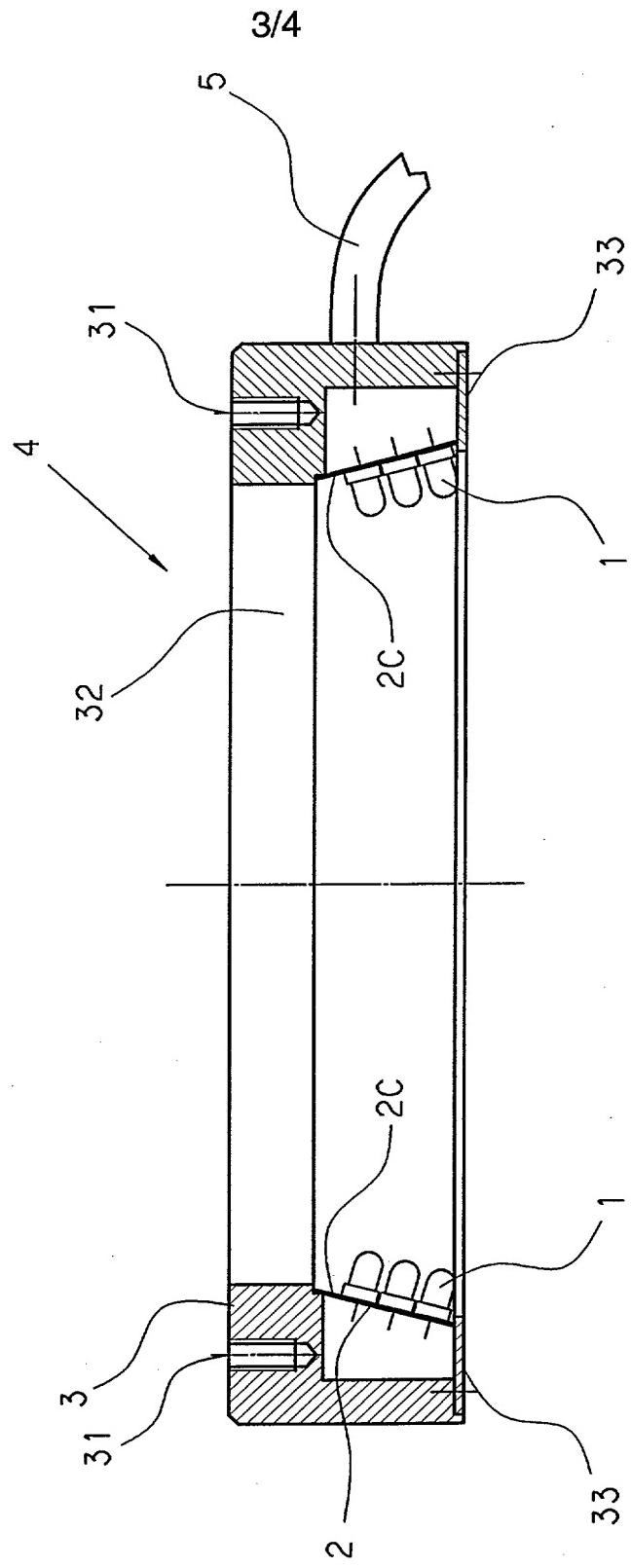


Fig. 3



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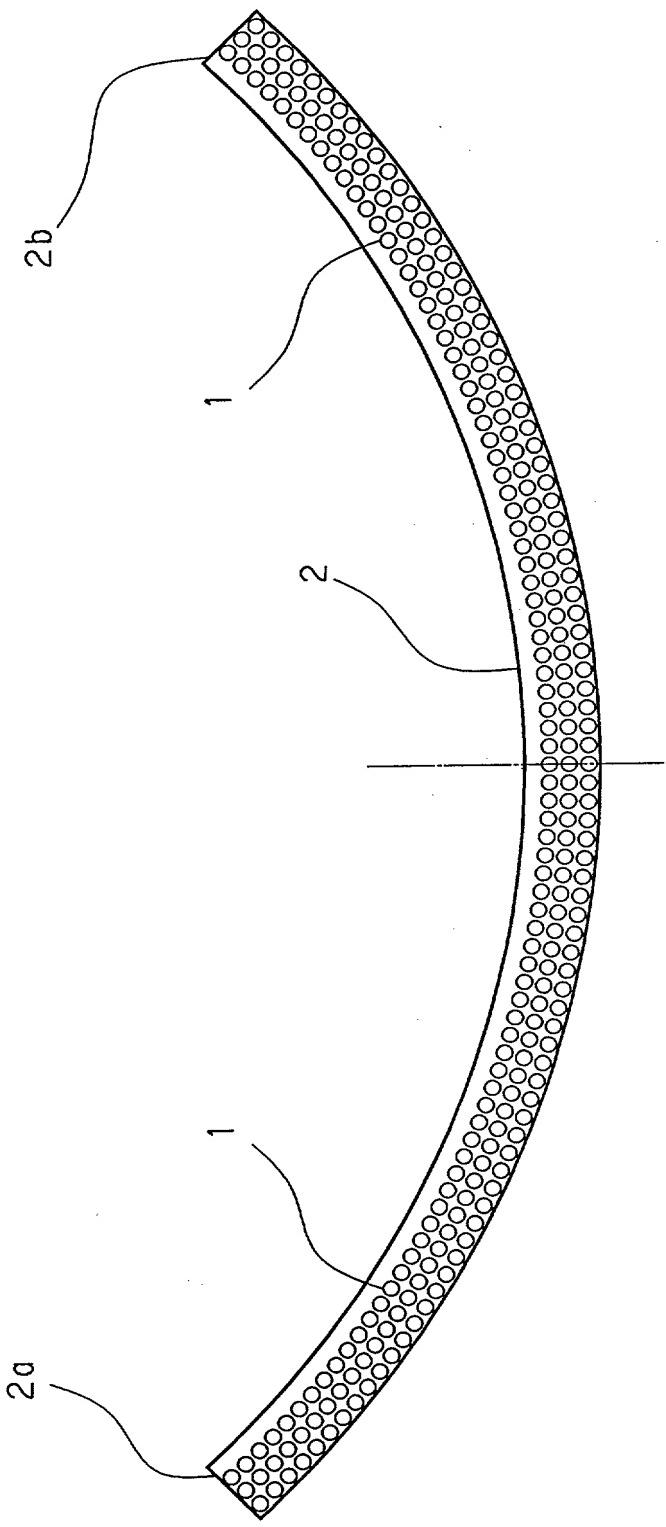


Fig. 4

SOLE DECLARATION FOR PATENT APPLICATION

As the below named inventor, I hereby declare that:

My residence, post office address and citizenship are as stated below next to my name;

I believe I am the original, first and sole inventor of the subject matter which is claimed and for which a patent is sought on the invention entitled METHOD OF MANUFACTURING LIGHTING UNIT

the specification of which

- is attached hereto.
- was filed on _____ as Application Serial Number _____ and was amended on _____ (if applicable).
- International (PCT) application No. _____, filed _____, and as amended on _____ (if any).

I hereby state that I have reviewed and understand the contents of the above identified specification, including the claims, as amended by any amendment referred to above.

I acknowledge the duty to disclose information which is material to the examination of this application in accordance with Title 37, Code of Federal Regulations, §1.56(a).

Prior Foreign Application(s)

I hereby claim foreign priority benefits under Title 35, United States Code, §119 of any foreign application(s) for patent or inventor's certificate listed below and have also identified below any foreign application(s) for patent or inventor's certificate having a filing date before that of the application on which priority is claimed:

Country	Application Number	Date of Filing (day, month, year)	Date of Issue (day, month, year)	Priority Claimed Under 35 U.S.C. §119
JAPAN	8/178034	08,07,1996		Yes

Prior United States Application(s)

I hereby claim the benefit under Title 35, United States Code, §120 of any United States application(s) listed below and, insofar as the subject matter of each of the claims of this application is not disclosed in the prior United States application in the manner provided by the first paragraph of Title 35, United States Code, §112, I acknowledge the duty to disclose material information as defined in Title 37, Code of Federal Regulations, §1.56(a) which occurred between the filing date of the prior application and the national or PCT international filing date of this application:

Application Serial Number	Date of Filing (Day, Month, Year)	Status — Patented, Pending, Abandoned

And I hereby appoint, both jointly and severally, as my attorneys with full power of substitution and revocation, to prosecute this application and to transact all business in the Patent and Trademark Office connected herewith the following attorneys who are all members of the Bar of the District of Columbia, their registration numbers being listed after their names:

Donald W. Banner, Registration No. 17,037; Harold J. Birch, Registration No. 16,527; Edward F. McKie, Jr., Registration No. 17,335; William W. Beckett, Registration No. 18,262; Dale H. Hoscheit, Registration No. 19,090; Joseph M. Potenza, Registration No. 28,175; Alan I. Cantor, Registration No. 28,163; James A. Niegowski, Registration No. 28,331; Barry L. Grossman, Registration No. 30,844; Joseph M. Skerpon, Registration No. 29,864; Thomas L. Peterson, Registration No. 30,969; Nina L. Medlock, Registration No. 29,673; William J. Fisher, Registration No. 32,133; Thomas H. Jackson, Registration No. 29,808; Franklin D. Wolffe, Registration No. 19,724; and Susan A. Wolffe, Registration No. 33,568.

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which is also the address and telephone number of each of the above listed attorneys.

I hereby declare that all statements made herein of my own knowledge are true and that all statements made on information and belief are believed to be true; and further that these statements were made with the knowledge that willful false statements and the like so made are punishable by fine or imprisonment, or both, under Section 1001 of Title 18 of the United States Code and that such willful false statements may jeopardize the validity of the application or any patent issuing thereon.

Signature Kenji Yoneda Date May 29, 1997
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